

Shp 24/10

Work Order ID 63090



October 20, 2010 3:12:23 PM

Item ID: D3891-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 10-10-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3891

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3891

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

10-10-20

[Stamp]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-20

Work Order ID 63090

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Page 2

Item ID: D3891-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2

10/20/10

130 Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

SB 10/10/21

2

140 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/21

mf 10-10-21

Picklist Print

October 20, 2010 3:12:23 PM

Page 1

Work Order ID: 63090

Parent Item: D3891-3

Parent Item Name: Gasket



Start Date: 10/20/10

Required Date: 10/21/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09.02.04 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	784.7000	3.704	7.797895			



4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"



1810-10-21

Location

Loc Qty

Loc Code

MAT

500

114937

500

MAT052

284.7

112335

284.7

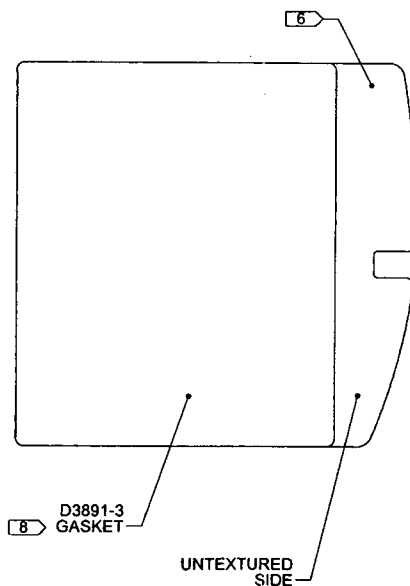
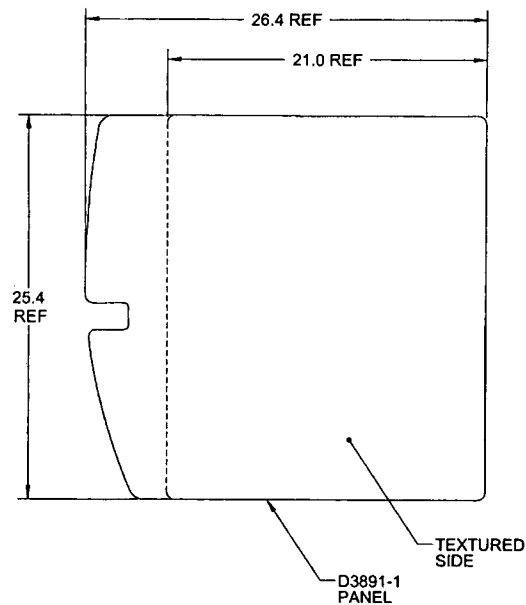
112338

(2)

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63090
0110-10-20



D3891-041 PANEL, FWD LH

NOTES:

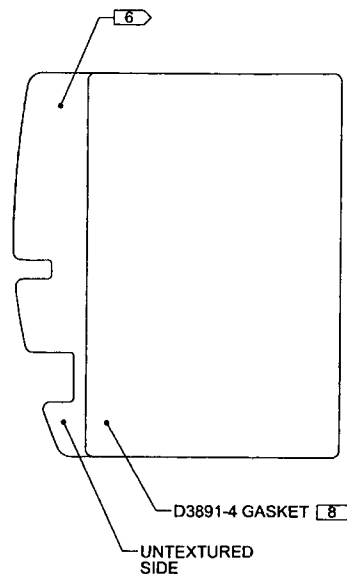
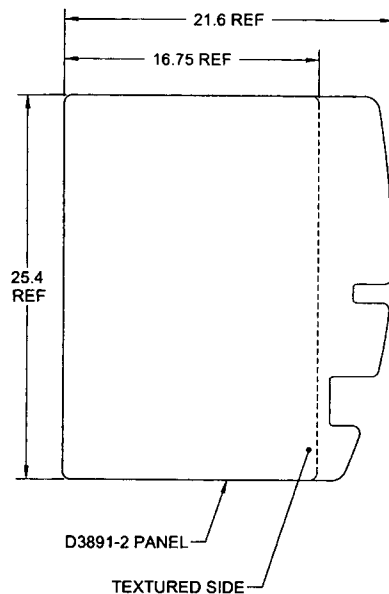
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED
C9/06/16 11/10

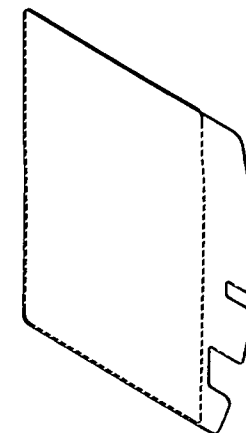
A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3891		SHEET 1 OF 6	
TITLE PANEL, FWD		SCALE NTS	
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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-042 PANEL, FWD RH



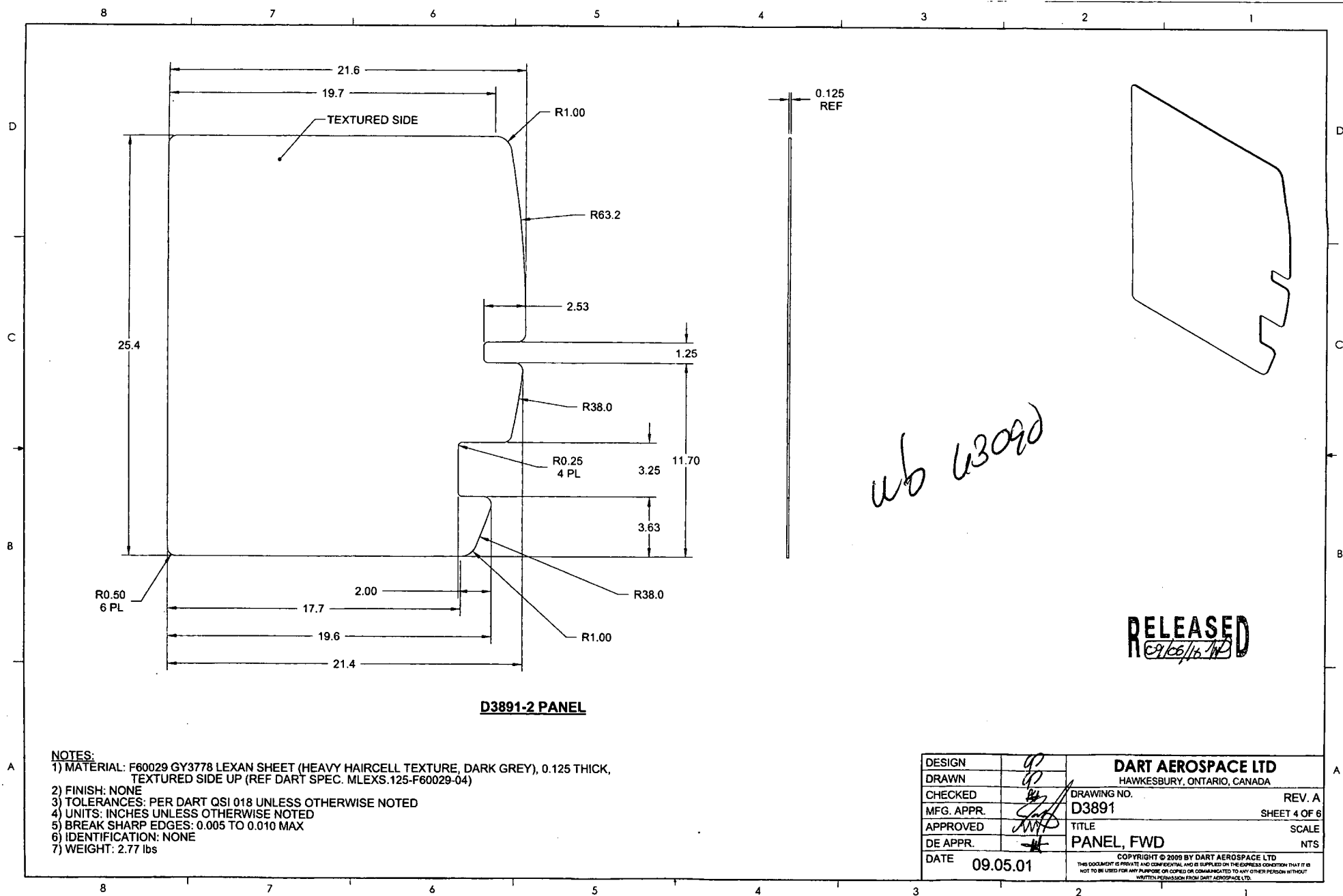
W6 43090

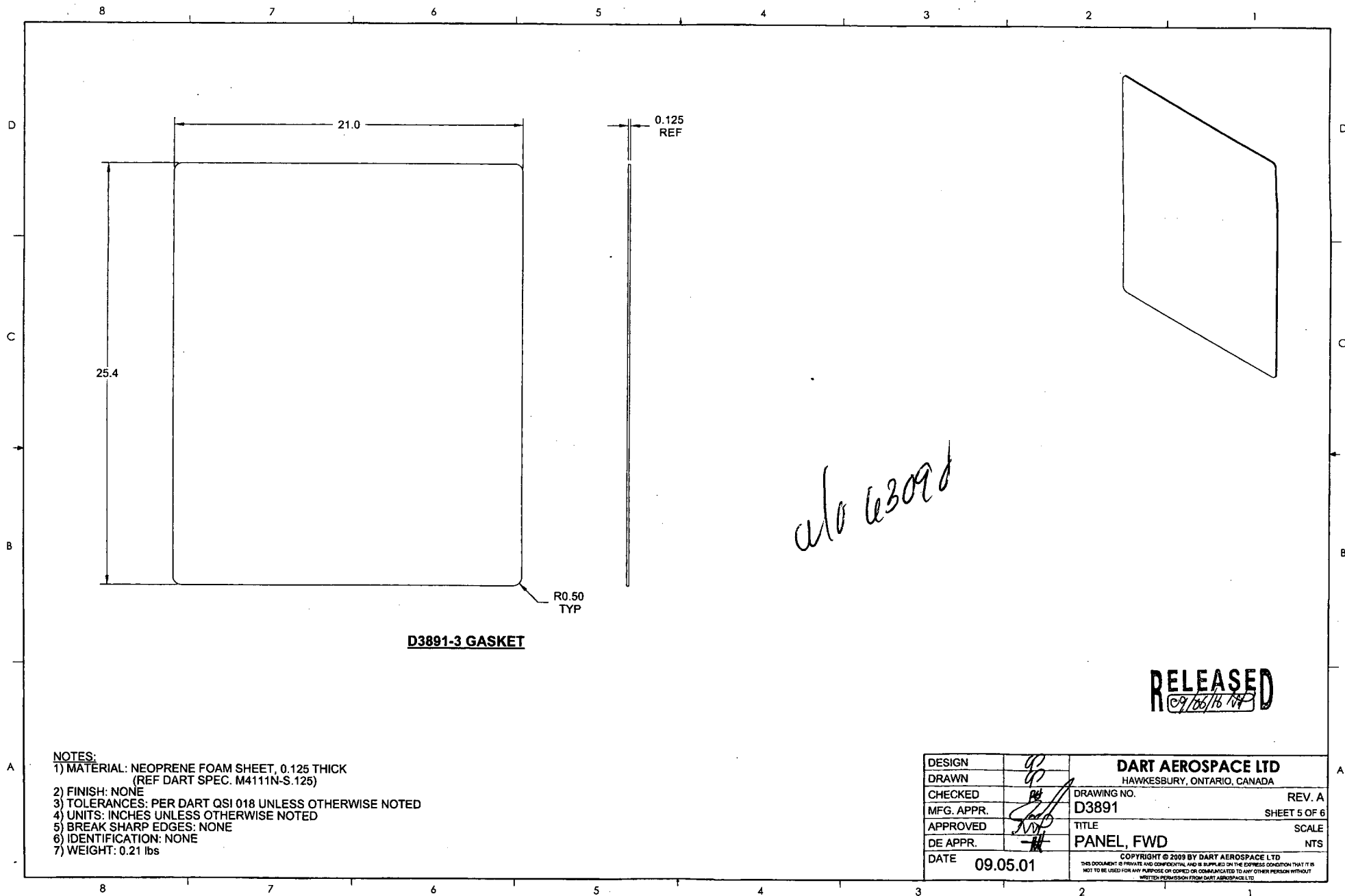
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED
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CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 2 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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D3891-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

RELEASED
09/05/10

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DE APPR.	92	PANEL, FWD	NTS
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